

Work Order ID 79159

79159

Page 1

January-23-12 9:07:58 AM

Item ID: D3959-1KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Tunnel, Aft Center

Start Date: 1/23/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/23/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3959 | B | | | | | | | | |

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size


12/01/23

105 0.00

105

HandThermo

Dry Material

Memo

0.00


Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 8:00 pm 12/01/22

Time OUT: 6:00 am 12/01/23


12/01/23

Work Order ID 79159***79159***

Page 2

January-23-12 9:07:58 AM

Item ID: D3959-1KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Tunnel, Aft Center

Start Date: 1/23/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/23/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00

110

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA056 using tool DT9332-A
Dwg Rev: B
Folio Rev: C

Wh
12/01/23

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

Wh
12/01/23

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

m 12-01-23 (1)

79159

January-23-12 9:07:58 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/23/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

0.00

140

0.00

HandThermo

Memo

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

150

0.00

150

0,00

QC

Memo

Quality Control

Complete FAI document

160

0.00

160

0.00

QC

Memo

Quality Control

79159

January-23-12 9:07:58 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/23/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/23/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

170 Identify as per dwg & Stock Location: THERMO

170

Packaging

Packaging

Memo

See also 78094.

0.00

0.00

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

12/1/23

12-01-23

Picklist Print

January-23-12 9:07:58 AM

Page 1

Work Order ID: 79159

Parent Item: D3959-1KGY

Start Date: 1/23/12

Required Date: 1/23/12

Parent Item Name: Vertical Tunnel, Aft Center

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Material 10/04/021 DL

IPP Rev B Add Step 105 Dry

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MKYD6185S.080-P3-
52068

Purchased

No

100

sf

811.6796

6.729

6.729

Kydex steel grey

Location

Loc Qty

Loc Code

therm

811.6795592

111807

10.4896282

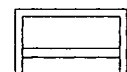
119476

801.189931

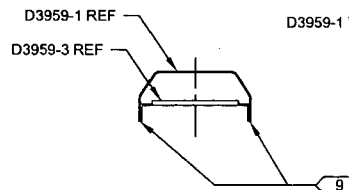
6.729 sf

12/01/23

| ITEM | QTY -041 KIV | QTY -041 KGY | PART NUMBER | DESCRIPTION |
|------|--------------------|--------------------|--------------|------------------------------------|
| | X | | D3959-041KIV | VERTICAL TUNNEL (IVORY) |
| | | X | D3959-041KGY | VERTICAL TUNNEL (STEEL GRAY) |
| 1 | 1 | | D3959-1KIV | VERTICAL TUNNEL (IVORY) |
| 2 | 1 | | D3959-1KGY | VERTICAL TUNNEL (STEEL GRAY) |
| 3 | | 1 | D3959-3KIV | DUCT, VERTICAL TUNNEL (IVORY) |
| 4 | | 1 | D3959-3KGY | DUCT, VERTICAL TUNNEL (STEEL GRAY) |
| 10 | A/R | A/R | EZ250150 | ADHESIVE, 3M SCOTCH WELD |

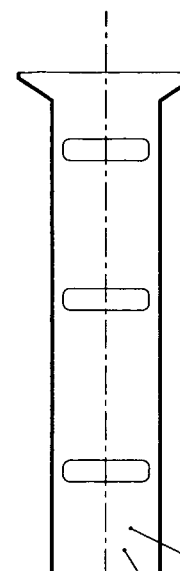
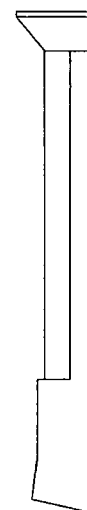
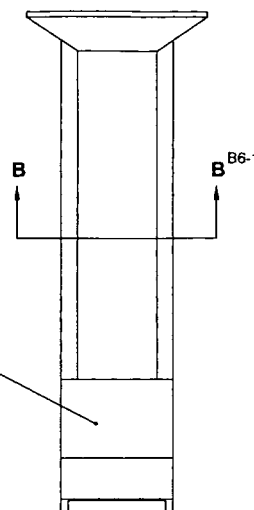
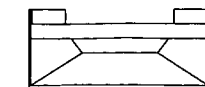


VIEW A-A B3-1



SECTION B-B C4-1

D3959-1 VERTICAL TUNNEL
TEXTURED SIDE



D3959-3 DUCT,
TEXTURED SIDE

SYM

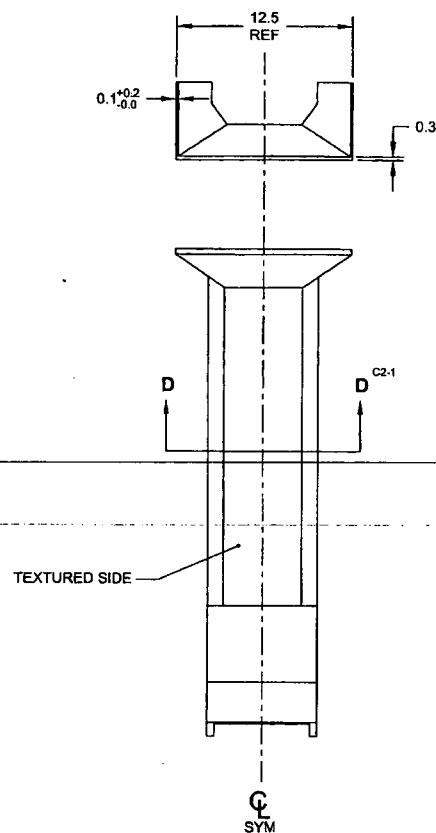
D3959-041 VERTICAL TUNNEL, AFT CENTER

NOTES:

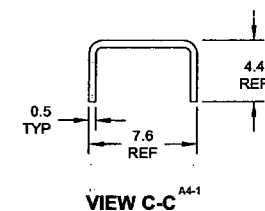
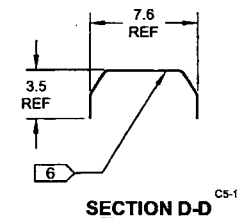
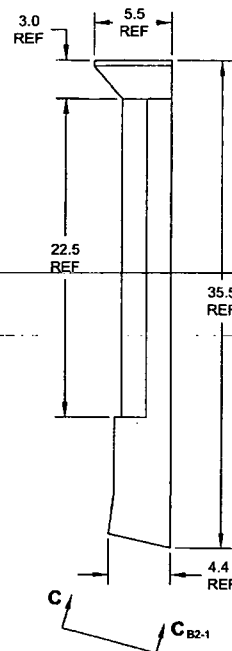
- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3959-041KIV OR D3959-041KGY USING VIBRATING STYLUS
- 7) WEIGHT: 2.8 lbs
- 8) TRIM D3959-3 DUCT AS REQUIRED TO ALLOW PROPER MATING
- 9) SEAL MATING EDGES WITH EZ250150 ADHESIVE ALONG MATING PERIMETER WITH MINIMUM THICKNESS OF 0.020"

RELEASED
2010-01-06

| | | | |
|------------|-------------|--|--------------|
| B | ADD -3/-041 | PH | 09.12.15 |
| A | NEW ISSUE | PH | 09.06.17 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | PH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | PH | D3959 | SHEET 1 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | VERTICAL TUNNEL (206 L3/L4) | NTS |
| DATE | 09.12.15 | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



D3959-1 VERTICAL TUNNEL, AFT CENTER



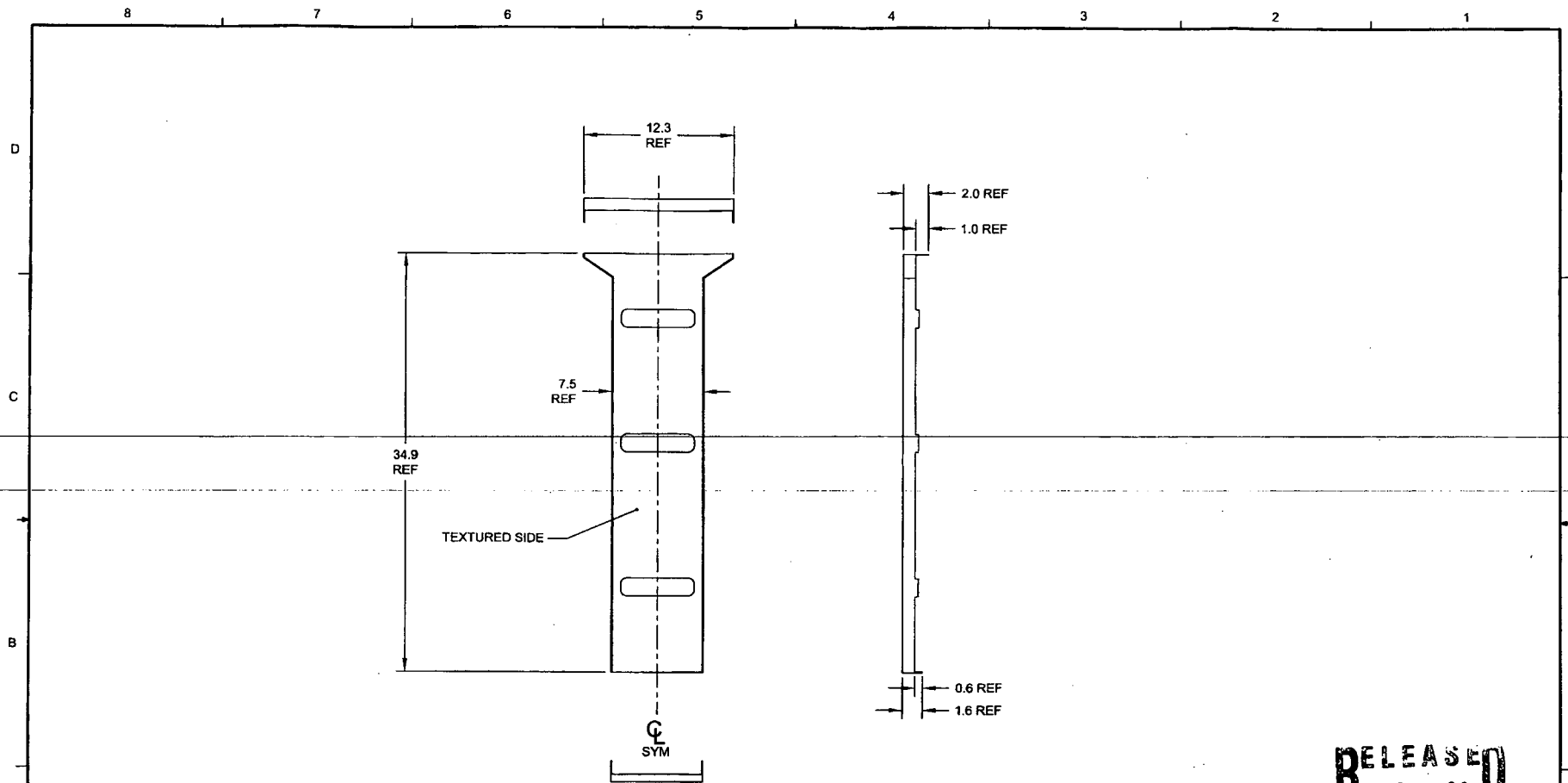
RELEASED
2010-01-06

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: SEE -041
- 8) TOOLING: THERMOFORM PER MOLD DT9332-A PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3959-1KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3959-1KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | | |
|--|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | PH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PH | DRAWING NO. | REV. B |
| MFG. APPR. | PH | D3959 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | VERTICAL TUNNEL (206 L3/L4) | NTS |
| DATE | 09.12.15 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |



D3959-3 DUCT, VERTICAL TUNNEL, AFT CENTER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: SEE -041
- 8) TOOLING: THERMOFORM PER MOLD DT9332-B PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

| PART NUMBER | DESCRIPTION |
|-------------|--|
| D3959-3KIV | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015) |
| D3959-3KGY | KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068) |

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | | |
| CHECKED | Q | DRAWING NO. | REV. B |
| MFG. APPR. | | D3959 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | VERTICAL TUNNEL (206 L3/L4) | NTS |
| DATE | 09.12.15 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

RELEASED
2010-01-06
mp

| | |
|---|--------------------------------|
| DART AEROSPACE LTD | Work Order: 79159 |
| Description: | Part Number: D3959-116Y |
| Inspection Dwg: D3959 Rev: B. | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than $\frac{1}{8}$ " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|-------------------------------|-----------------------|
| Measured by: <i>DL</i> | Date: 12/01/23 |
|-------------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------|------------------|--------|--------|----------------------|----------|
| 12.5" | Ref | 12.625" | ✓ | | TAPE DL-01 | |
| 0.1" | ± 0.002 " | 0.275" | ✓ | | Uem DL-02 | |
| 5.5" | Ref | 5.625" | ✓ | | TAPE DL-01 | |
| 35.5" | Ref | 35.125" | ✓ | | TAPE DL-01 | |
| 7.6" | Ref | 7.625" | ✓ | | TAPE DL-01 | |
| 3.5" | Ref | 3.3" | ✓ | | TAPE DL-01 | |
| 0.5" | ± 0.100 " | 0.483" | ✓ | | Uem DL-02 | |
| 4.4" | Ref | 4.4" | ✓ | | TAPE DL-01 | |
| 0.035" | M.N. | 0.043 MIN | ✓ | | Uem DL-02 | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | |
|-------------------------------|-----------------------|
| Measured by: <i>DL</i> | Date: 12/01/23 |
| Audited by: <i>J</i> | Date: 12/01/23 |
| Preliminary Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10-04-14